

Work Order ID 55339

Page 1

January 13, 2010 10:26:55 AM

Item ID: D3508-3

Accept



Setup Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 1/13/10 Start Qty: 6.00



Cust Item ID:

Required Date: 1/20/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: *RJ*Date: *10-1-13*

Tooling:

Date: _____

Run Start



QC:

Date: _____

SPC (Y/N):

Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3508	Rev C

100 Waterjet FLOW WATER JET 0.00



Waterjet

Memo

0.00

RJ 10-1-18

FLOW CNC Waterjet

1-Cut as per Dwg D3508 Dwg Rev: *C* Prog Rev: *C* 2-
Deburr if necessary*(7)**304.00*

110 QC2- Inspect parts off machine FAI/FAIB 0.00



QC

Memo

0.00

RJ 10-1-18

Quality Control

120 QC8- Inspect parts - second check 0.00



QC

Memo

0.00

*=> 51061/18**x6**PJO ->*

Quality Control

W/O: 55339

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/1/18	#120	Took Qty x1 Part for QC inspection Template	S	10/01/18	x1	✓	✓ 10/01/18

Part No: D3508-3 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Work Order ID 55339



Page 2

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



NC BRAKE

0.00

6

Brake NC

Memo

0.00

Brake NC

1-Form on brake using DT8326 and DT8261as per Dwg D3508 12-Form joggle
as per Dwg D3508 Using DT8158

SB 10/01/19

140



QC5- Inspect part completeness to step on W/O

0.00

→ S1010120

QC

Memo

0.00

(X6)

Quality Control

150



Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

M1112588

Memo

0.00

⇒ M 10/01/21

Powdercoat

Powder Coating

START TIME: 6:45AM COVEN TEMPERATURE:
FINISH TIME: 7:15AM 370°F

(X6)

S

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Page 1

January 13, 2010 10:27:00 AM

Work Order ID: 55339



Parent Item: D3508-3



Parent Item Name: Wearplate

Start Date: 1/13/10

Required Date: 1/20/10

Comments: IPP Rev:A New Issue 06-06-20 JLM
IPP Rev:B Now SS as per Rev B 06-12-15 JLM
IPP Rev:C Rev C dwg 07-12-06 DD

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ M304S20GA	Replacement	Mfg/ Purchased	Bin	Primary	Last	Route	Unit of sf	Qty on 286.5294	Remaining 4.6358	Qty	Date	Status
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304/316 .040 Sheet

5.4126

1B 10-1-18

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	286.5294053	
110076	0.40253684	
112567	38.0765789	
112885	83.1578	
113062	156.3723	113062
113077	8.52018947	

(7)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	53339
Description: Wearplate	Part Number:	D3508-3
Inspection Dwg: D3508 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	HR	Audited by:	S	Prototype Approval:	N/A
Date:	10-1-19	Date:	10/01/19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.15	New Issue	KJ/DD	

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 55339

R10-113

31.62

28.125

5 EQ. SPACES

5.625 PITCH

0.375

DETAIL A

R0.062

Ø0.188

(TYP 2 PLACES)

2.063

2.813

R0.063

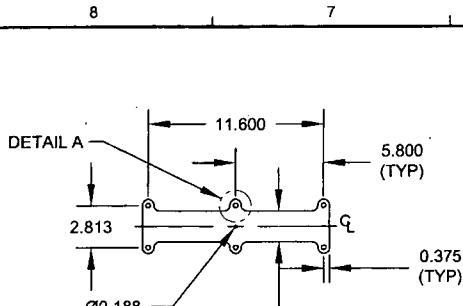
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(TYP 2 PLACES)

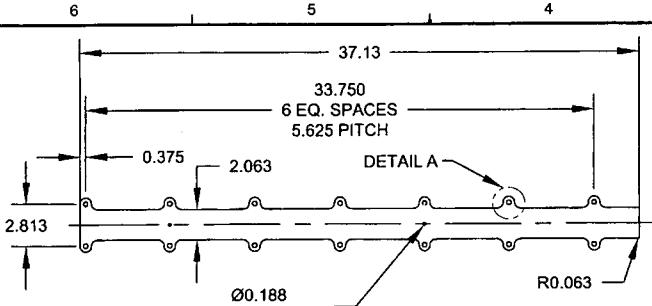
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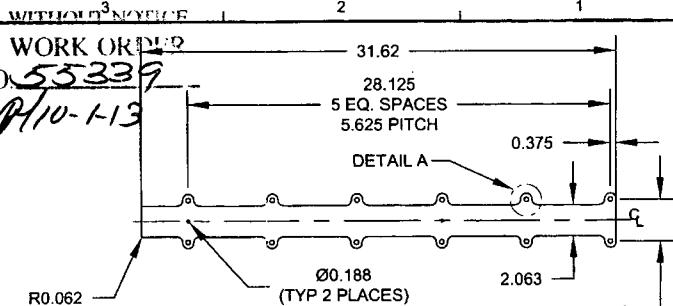
D3508-5 FLAT PATTERN



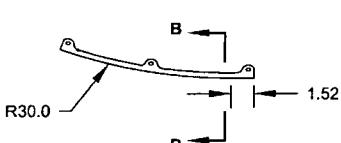
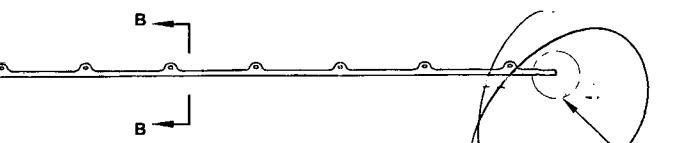
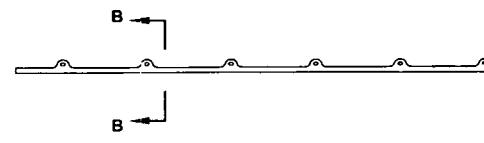
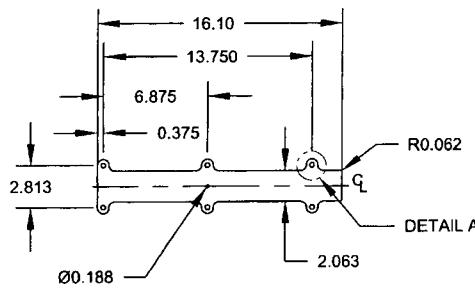
D3508-1 FLAT PATTERN



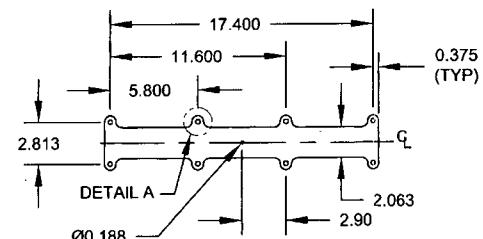
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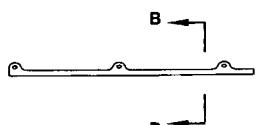
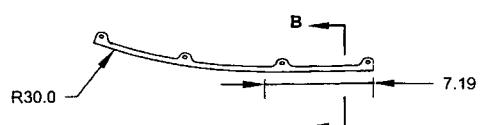
D3508-5 FLAT PATTERN

D3508-1 BENDING DETAIL
(MAKE FROM D3508-1F)D3508-3 BENDING DETAIL
(MAKE FROM D3508-3F)D3508-5 BENDING DETAIL
(MAKE FROM D3508-5F)

D3508-7F FLAT PATTERN



D3508-9F FLAT PATTERN

D3508-7F BENDING DETAIL
(MAKE FROM D3508-7F)D3508-9F BENDING DETAIL
(MAKE FROM D3508-9F)

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF. DART MATERIAL SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.015
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: D3508-1 - 0.47 lbs, D3508-3 - 0.95 lbs, D3508-5 - 0.77 lbs,
D3508-7 - 0.39 lbs, D3508-9 - 0.45 lbs, D3508-11 - 0.64 lbs
D3508-13 - 0.25 lbs

RELEASED
07.11.16

C	ADD -9/-11-13 MOVE TAB OUTBOARD (2.813 WAS 2.733) CHANGE DRAWING FORMAT	PH	07.04.20
B	CHANGE STAINLESS STEEL, WIDEN	PH	06.10.27
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>AS</i>	DART AEROSPACE USA, INC	
DRAWN	<i>AS</i>	PORT HADLOCK, WA	
CHECKED	<i>AS</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>AS</i>	D3508	SHEET 1 OF 2
APPROVED	<i>AS</i>	TITLE	SCALE
DE APPR.	<i>AS</i>	WEARPLATE	1:8
DATE	07.04.20	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS NOT TO BE COPIED OR DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

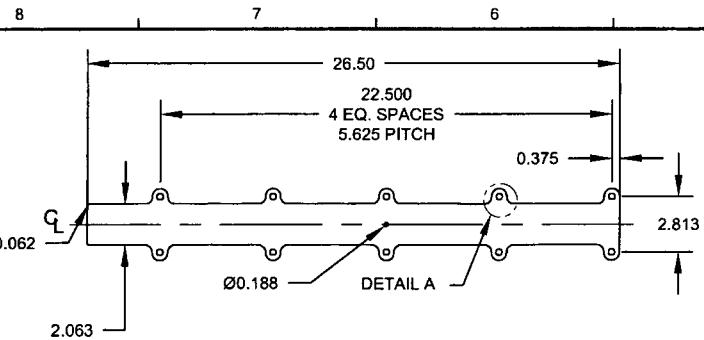
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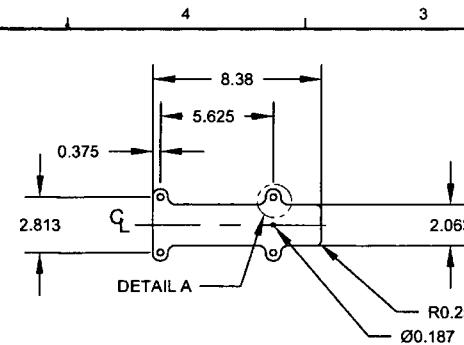
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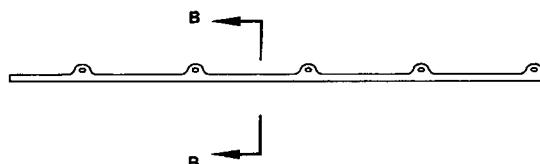
NOTE: Date & initial all entries



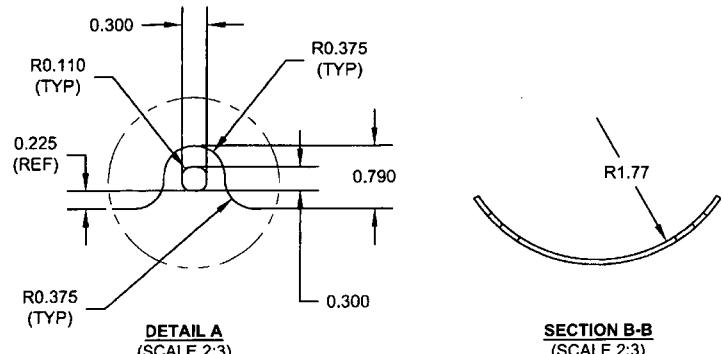
D3508-11F FLAT PATTERN



D3508-13F FLAT PATTERN



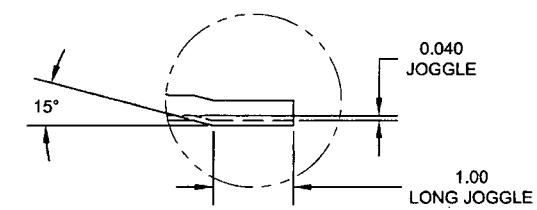
D3508-11 BENDING DETAIL
(MAKE FROM D3508-11F)



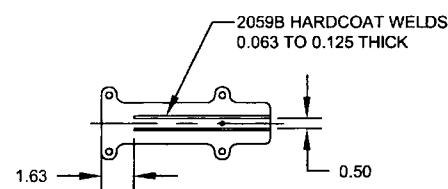
SECTION B-B
(SCALE 2:3)



D3508-13 BENDING DETAIL
(MAKE FROM D3508-13F)



DETAIL C
(SCALE 1:2)



D3508-13 WELDING DETAIL

RELEASED
07/14/14

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	PH	REV. C	
MFG. APPR.	EP	DRAWING NO. D3508	
APPROVED	EP	SHEET 2 OF 2	
DE APPR.	EP	TITLE WEARPLATE	
DATE	07.04.20	SCALE 1:6	

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